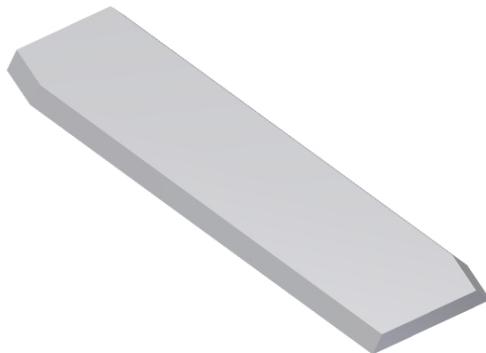


# 2-sided Wood Inserts with chamfer

A09-900

The cycle time for a 2-sided reversible knife includes handling - loading and rotating - as well as the grinding of the 2 sides. To keep the time low grinding and handling operations have been optimized to a minimum of movements and the usage of one single wheel, which allows to grind the 45° clearance of the main cutting edge and the chamfer in one pass. After having rotated the reversible knife, a location probing is necessary



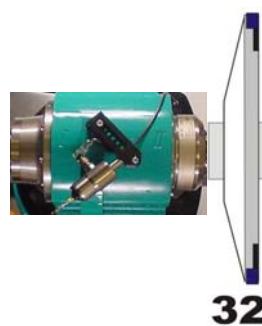
## 1. Cycletime for Production

Tool specifications from rectangular blank 50x14 Material CARBIDE							
Operations	Chamfer	1st side	Rotate tool	Probing	Chamfer	2nd side	Loading
Feed [mm/Min]	200	500	2000	200	200	500	2000
Power [kW]	1	1		1	1	1	
Cutting feed [m/s]	34	34		34	34	34	
Used wheels							
Grinding time [s]	32	32		32	32	32	
Total cycle time	1 Min 13						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

32 Ø250 12C9 D64



## 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, STL 650  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.3

responsible engineer: KOC, 12.8.08

[www.schneeberger.ch](http://www.schneeberger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

**TECHNOLOGY  
FOR TOOLING**